

**Work Order ID 66358**

Friday, February 11, 2011 1:13:14 PM

Page 1



Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 2/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

CMF

Date: 11-02-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3274

D

IIN-D206-642

Rev M

0.00

100



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile &amp; type labels per PPP D206-642-541

CHG003

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

\*\*\*\*VERIFY AND INSPECT THE MATERIAL PRIOR TO USE\*\*\*\*

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

DP 11-3-10

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

DP 11-3-16

3- weld fwd cap as per dwg D3274 and OSI004

AR Aluminum Rod Batch: M111385/M116577

BE 11-3-23

4- grind fwd cap weld on top surface only

BE 11-3-23

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

BE 11/03/23

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

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Customer:

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Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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114

QC5- Inspect part completeness to step on W/O

0.00

Sub 6/23



QC

Memo

0.00

Quality Control

116

QC10- Inspect visual per QSI004- ground welds

0.00

Sub 6/23



QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1

BB 11/03/28

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Start Date: 2/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP

11-4-5

150

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 &amp; QSI 015.

A/R ☐ Sikaflex-291 ☒ M116948 ☐Sikaflex expire date: ☐ 12-1-15 ☐Start: ☐ 11-4-5 ☐ Time: ☐ 5:30 PMFinish: ☐ 11-4-6 ☐ Time: ☐ 8 AM

(Adhere for 12 hours)

&gt;

DP

11-4-5

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Subonly

(H)

170



Skidtubes

Skidtubes

Skidtubes

0.00

Memo

0.00

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2  
OPEN HOLES TO .297" . Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD  
END OF TUBEDEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)  
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

=&gt; SAD 11-04-29

BE 11/05/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 2/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC3- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

190

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R ☐ Aluminum Rod ☒

M111385

BE 11/05/07

3-Grind cross bolt welds flush as per Dwg D3274.

BE 11/05/10

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

BE 11/05/11

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 2/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/28/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 11/05/12

210

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8 11/05/12



220

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

IX ~~Ø~~ m.d 11/05/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 66358



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Friday, February 11, 2011 1:13:14 PM

Item ID:	D206-642-541	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Replacement Skidtube					
Start Date:	2/14/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	2/28/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230  Powdercoat Powder Coating M116964	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo START TIME: 12:50 OVEN TEMPERATURE: 320°F FINISH TIME: 1:20	0.00				1X	0	M/11/05/12	
240  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00				1	0	M/11/05/13	
250  HandFinish Hand Finishing	HandFinishing  Memo 1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. A/RON/A□LPS-3□ M109956  2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/R□□Sikaflex-291 □ M110945 Sikaflex expire date: □ 12/10	0.00				1	0	M/11/05/13	

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Friday, February 11, 2011 1:13:14 PM

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Start Date:	2/14/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	2/28/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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260	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	Inspect Nut Plate & Inserts								

270	HAND FINISHING RESOURCE #1	0.00							
HandFinish	Memo	0.00							
Hand Finishing	1-Install wearpads & gaskets as per Dwg D3274.								

- 2-Install ring as per Dwg D3274
- ✓ A/R ☐ Sikaflex-291 ☐ 1116945
- Sikaflex expire date: ☐ 12/01
- 3-Inspect for foreign objects as per QSI 024
- 4-Spray inside of tube on both sides of web with LPS-3
- A/R LPS-3 Batch: 12/19
- 5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.
- ✓ A/R ☐ Sikaflex-291 ☐ 1116945
- Sikaflex expire date: ☐ 12/01

④

1 of 11 2/10/13

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

280

QC5- Inspect part completeness to step on W/O

0.00

8/11/16



QC

Memo

0.00

Quality Control

290

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

PPP 663600

Packaging

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*(Signature)*

*Pay/6/80*

*11/6/19*

*MF*  
*11-06-08*

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Friday, February 11, 2011 1:13:07 PM

Page 1

Work Order ID: 66358

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 2/14/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM  
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM  
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD  
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC  
 IPP Rev:F 08-06-02 add comment DD verified by:EC  
 IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-1-190

Manufactured

No

110

Each

43.0000

1

1



Extrusion Round 3" 206

Location

Loc Qty

Loc Code

LG

43

47575

2

59874

41

D3285-1

Manufactured

No

110

Each

114.0000

1

1



Cap

Location

Loc Qty

Loc Code

LG

114

52511

66

52647

48

D3282-041

Manufactured

No

150

Each

4.0000

1

1



Float Web (206L/407)

Location

Loc Qty

Loc Code

LG

4

65292

1

65293

3

DP 11-3-10

BE 11-03-23

DP 11-24-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 2/14/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

D2649 Manufactured No 190 Each 243.0000 12 12  
Cross Bolt Spacer

Location	Loc Qty	Loc Code
LG	243	
58545	2	
60652	4	
61496	2	
62889	11	
63359	3	
65317	221	

B.E 11/05/07  
B 68507 (12)

D3275-1 Manufactured No 190 Each 53.0000 12 12  
Crossbolt Spacer

Location	Loc Qty	Loc Code
LG	53	
53453	8	
62399	1	
63546	19	
65295	25	

B.E 11/05/07  
B 66109 (12)

CR3212-4-03 Purchased No 250 Each 1,863.000 2 2  
Cherry Rivet

Location	Loc Qty	Loc Code
ST311	1863	
110153	35	
111359	5	
112314	2	
114436	448	
114450	31	
114859	1342	

M 110189 12

Friday, February 11, 2011 1:13:08 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Friday, February 11, 2011 1:13:08 PM

Page 3

Work Order ID: 66358

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 2/14/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

D3415-041	Manufactured	No	250	Each	25.0000	1	1
							<u>all 2/10/11</u>
Nut Plate							

Location

Loc Qty

Loc Code



ST056

25

33842

25

21

CCR264SS3-3	Purchased	No	250	Each	154.0000	2	2
							<u>all 2/10/11</u>
Cherry Rivet							

Location

Loc Qty

Loc Code

ST311

154

112314

4

113539



44

113973

106

1117086

22

ALS4-1032-130	Purchased	No	250	Each	1,355.000	78	78
							<u>all 2/10/11</u>
Insert							

Location

Loc Qty

Loc Code

PKG11

1220

114723

220

116864

1000

1114331

278

ST282

96

110511

10

115911

86

ST381

39

114654

39

Friday, February 11, 2011 1:13:08 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 11, 2011 1:13:08 PM

Work Order ID: 66358

Parent Item: D206-642-541


Parent Item Name: Replacement Skidtube

Start Date: 2/14/2011

Required Date: 2/28/2011

Start Qty: 1.00


Required Qty: 1.00

D3536-15      Manufactured      No      270      Each      10.0000      1      1  
  
 Gasket

Location	Loc Qty	Loc Code
FP	1	066559
56055	1	
FP011	8	
63568	8	
FP11	1	
59238	1	

HL 110513


XL  
            
            
            
            
          

D3536-23      Manufactured      No      270      Each      11.0000      1      1  
  
 Gasket

Location	Loc Qty	Loc Code
FP011	1	
63570	1	1353468
ST	10	
66240	10	

HL 110513

XL  
            
            
            
          

D3536-35      Manufactured      No      270      Each      16.0000      1      1  
  
 Gasket

Location	Loc Qty	Loc Code
FP012	16	
58683	1	
63579	1	
65573	2	
66237	12	

HL 110513

            
            
            
            
XL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 11, 2011 1:13:08 PM

Page 5

Work Order ID: 66358

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 2/14/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-39      Manufactured      No      270      Each      19.0000      1      1  
Gasket  
yl 11/05/13

Location      Loc Qty      Loc Code

FP012      18

63578      6

66241      12

FP12      1

58215      1

D3535-15      Manufactured      No      270      Each      3.0000      1      1  
Wearshoe  
yl 11/05/13

Location      Loc Qty      Loc Code

FP18      3

63569      3

D3535-35      Manufactured      No      270      Each      12.0000      1      1  
Wearshoe  
yl 11/05/13

Location      Loc Qty      Loc Code

FP018      12

65926      12

D3535-39      Manufactured      No      270      Each      13.0000      1      1  
Wearshoe  
yl 11/05/13

Location      Loc Qty      Loc Code

FP-18      13

64076      13

Friday, February 11, 2011 1:13:08 PM

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Page 5

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Friday, February 11, 2011 1:13:08 PM

Page 7

Work Order ID: 66358

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 2/14/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C416 NAS1149C0463 Purchased No

270 Each 29.0000 1 1



washer

M115358



all 1105113

## Location

## Loc Qty

## Loc Code

ST346

29

100993

29

D3672-1 Manufactured No

270 Each 1,149.000 2 2



Phenolic Washer



all 1105113

## Location

## Loc Qty

## Loc Code

ST077

1149

42329

10

52505

139

64177

1000

AN3C4A Purchased No

270 Each 1,420.000 80 80



BOLT



all 1105113

## Location

## Loc Qty

## Loc Code

ST350

1420

115300

25

116075

361

116590

34

116704

1000

AN4C5A Purchased No

270 Each 439.0000 1 1



BOLT



all 1105113

## Location

## Loc Qty

## Loc Code

ST346

439

110552

1

112243

438

xl

Friday, February 11, 2011 1:13:08 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**\*NOTE:** Date & initial all entries

# Picklist Print

Friday, February 11, 2011 1:13:08 PM

Page 8

Work Order ID: 66358

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 2/14/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

76.0000

1

1



Aft Cap



ul 11/08/11

Location

Loc Qty

Loc Code

FP-4

6

57332

6

FP6

16

52663

3

62678

12

63633

1

Return 2010

54

62678

54

xl

D3413-1

Manufactured No

270

Each

25.0000

1

1



Ring



ul 11/08/11

Location

Loc Qty

Loc Code

ST420

9

62961

9

ST473

16

51586

1

53446

5

65294

10

xl

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

RELEASED

07.02.12

DEO ATTACHED

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY SCALE NTS	
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

**GENERAL NOTES:**

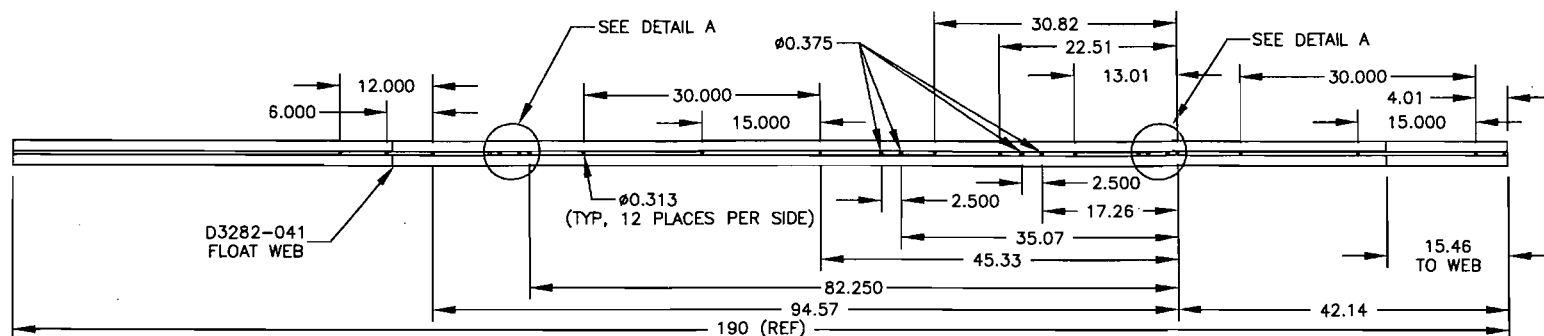
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1  
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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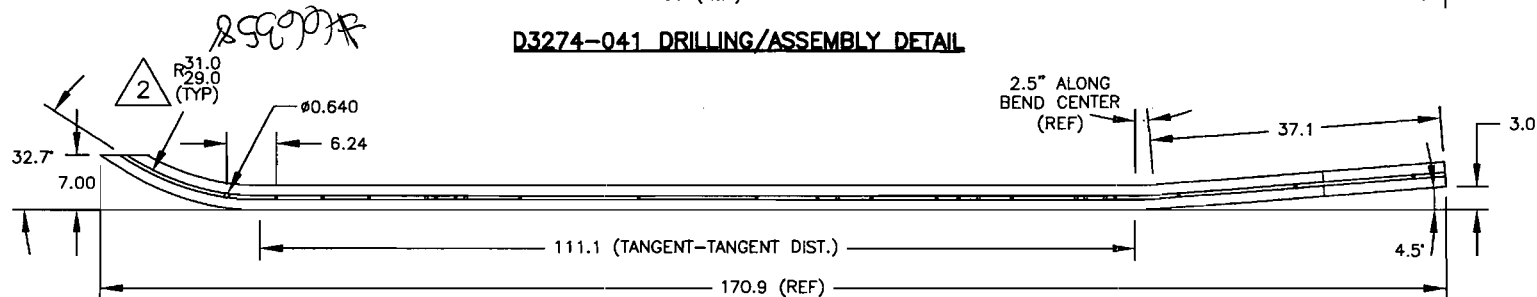
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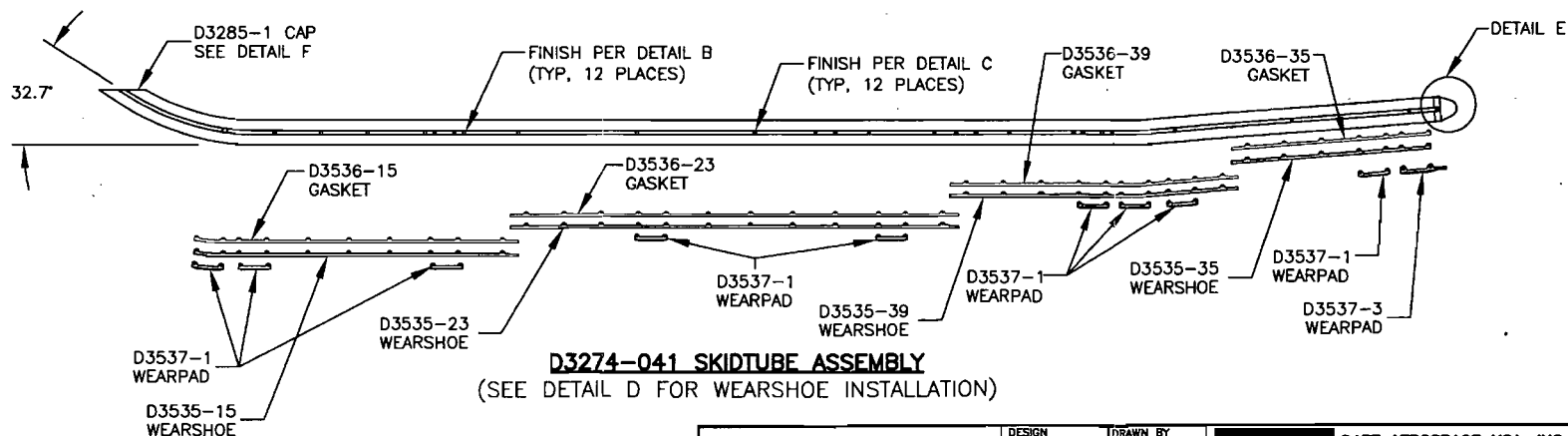
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**D3274-041 DRILLING/ASSEMBLY DETAIL**



**D3274-041 BEND/DRILLING DETAIL**



**D3274-041 SKIDTUBE ASSEMBLY**  
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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07.02.12

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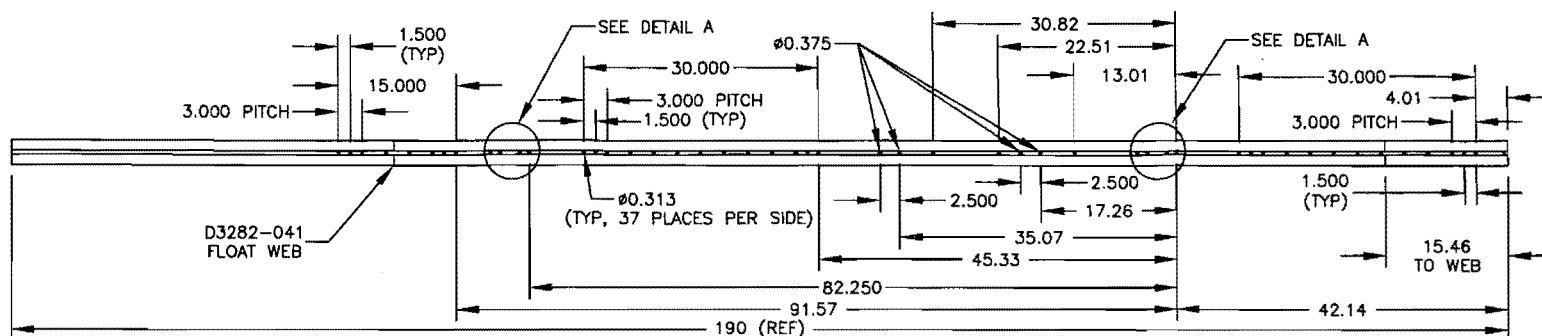
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DESIGN	CP	DRAWN BY	PH	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	#	APPROVED	#	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 2 OF 4 SCALE 1:15

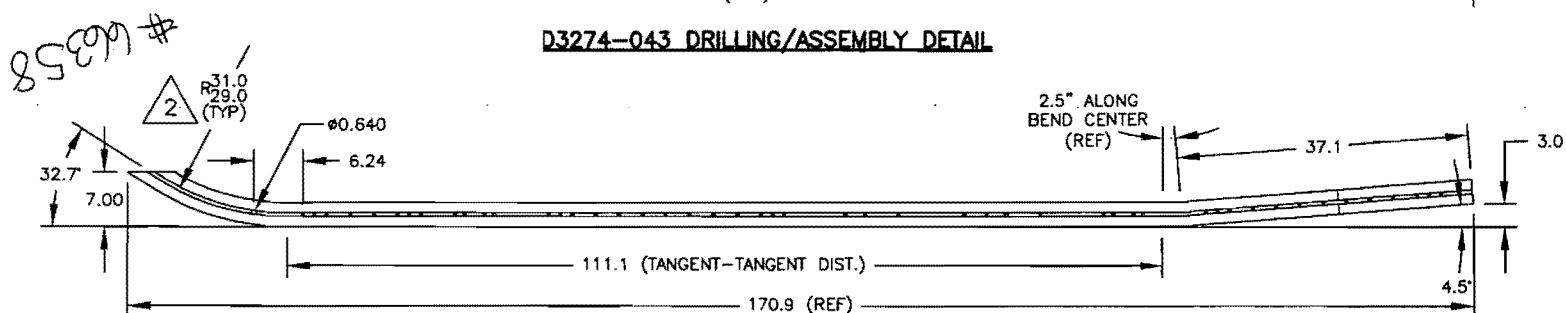




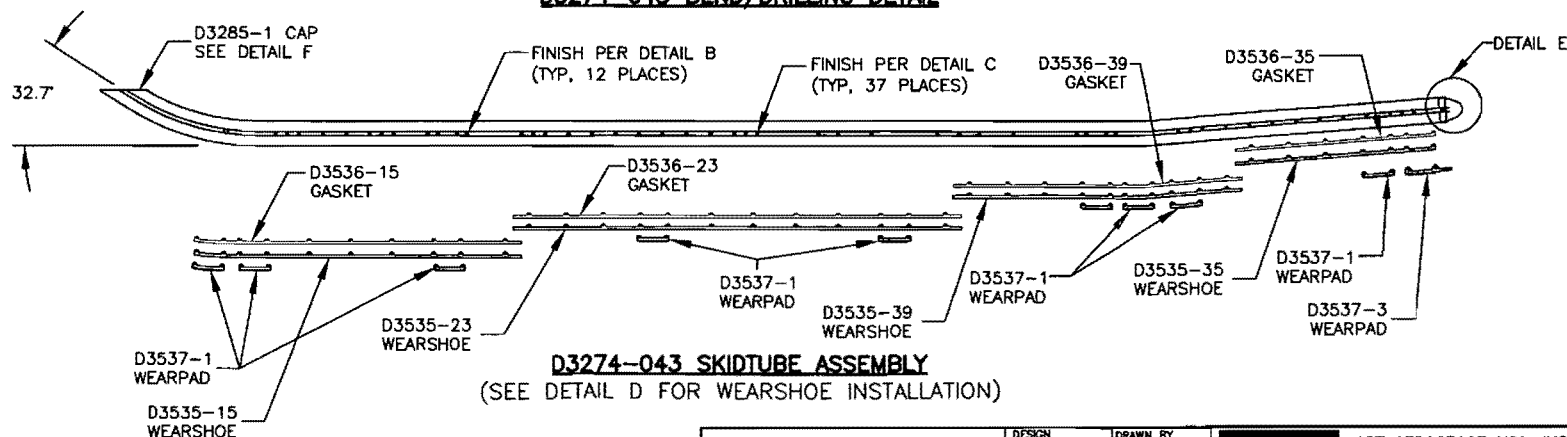
DEO ATTACHED



**D3274-043 DRILLING/ASSEMBLY DETAIL**



**D3274-043 BEND/DRILLING DETAIL**



**D3274-043 SKIDTUBE ASSEMBLY**  
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

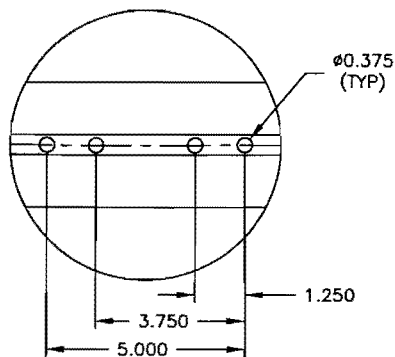
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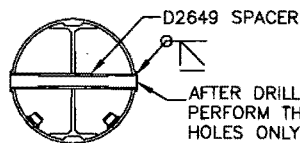
DESIGN	CP	DRAWN BY	PH	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	#	APPROVED	#	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 3 OF 4 SCALE 1:15



# **DETAIL A: DRILL DETAIL**

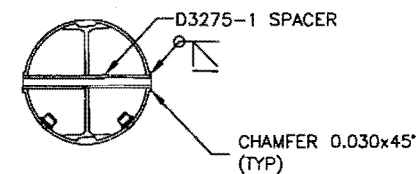


# **DETAIL B** FOR 0.375 HOLES ONLY

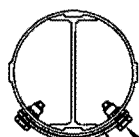


- AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR 0.375  
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE AND GRIND FLUSH
  4. C'BORE TO 0.313x0.75 DEEP

# **DETAIL C** FOR 0.313 HOLES ONLY



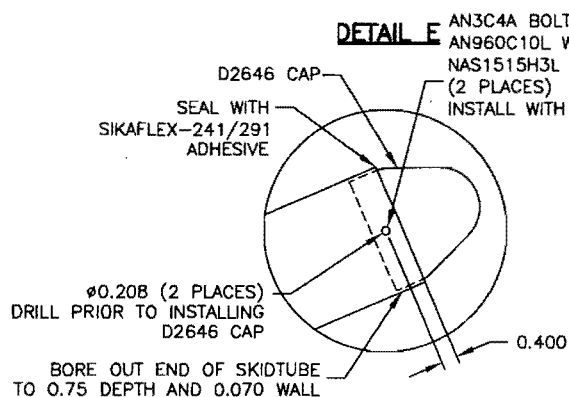
# **DETAIL D**



- ALS7-1032-130 INSERT (1)  
AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

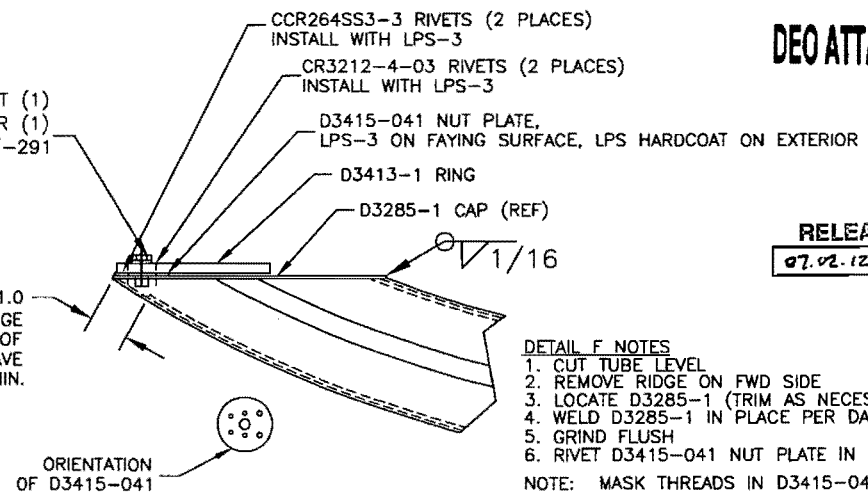
# **DETAIL E**



- AN4C5A BOLT (1)  
AN960C416 WASHER (1)  
INSTALL WITH SIKAFLEX-241/-291

REMOVE RIDGE  
ON INSIDE OF  
SKIDTUBE LEAVE  
0.070 MIN.

# **DETAIL F: END FINISHING DETAIL**



- DETAIL F NOTES**
1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D3285-1 (TRIM AS NECESSARY)
  4. WELD D3285-1 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

**DEO ATTACHED**

**RELEASED**  
07.02.12

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DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY		SCALE 1:3	

10

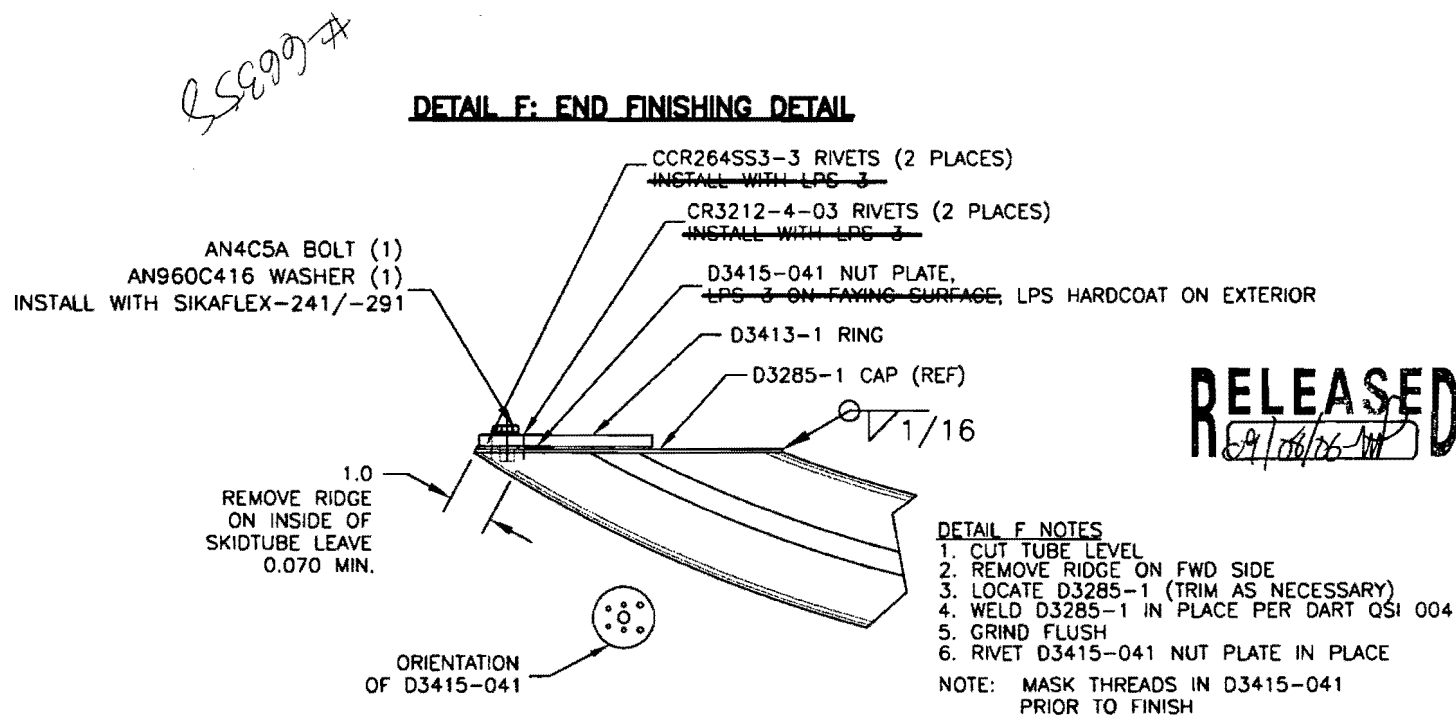
11

DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	<b>DART AEROSPACE USA, INC</b> <b>ENGINEERING ORDER</b>	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>L</i>	MFG. APPR. <i>M</i>	APPROVED <i>MAP</i>	DE APPR. <i>#</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: "~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:





NO. 251

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 68708-68708  
Part number: 205-634-041  
Description: 205  
Welding Process: Tig[ ] Mig[ ]  
Base material: Aluminum  
Current: AC[ ] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[ ] fail[ ]  
Penetration: pass[ ] fail[ ]

UNACCEPTABLE

Cracks: pass[ ] fail[ ]  
Undercut: pass[ ] fail[ ]  
Pin holes: pass[ ] fail[ ]  
Overlap (cold lap): pass[ ] fail[ ]  
Porosity (surface): pass[ ] fail[ ]  
Coloration: pass[ ] fail[ ]

Qualifier Ratz Evers Date of Test Coupon 11-05-05  
Welder Barclay Elliott Date of Test Coupon 11-05-05

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

15

15

15